

AWC-022



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 19/07/24 AUTH SAN
RELEASED AUC DATE AUG 2, 2019

DAS
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8-89

6F9540V00231

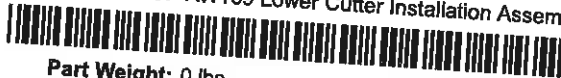
Job Sheet R198313



Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Job Created: 7/24/19

Due Date: 8/9/19

Type: Rework

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

SA 19/07/24

Priority: Medium

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Packaging 1 - Pick Kit	1 pcs		8/9/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

At 19-7-25



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S200553



Part: 6F9540V00231

Job No: R198313

Serial No/Batch: S200553

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 07/25/19

Plex 7/24/19 3:16 PM dart.lacelle.linda

115 Small Fab - 2 - B4B	1 pcs	8/9/19	0.00 1.00	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
120 Conventional Mill - 1 - B4B	1 pcs	8/9/19	0.25 0.33	Small Fab - 6 - B4B	AS 19-7-25
				Small Fab - 7 - B4B	
				Conventional Mill - 1 - B4B	
125 QC 5	1 pcs	8/9/19	0.00 0.00	Conventional Mill - 2 - B4B	DAS 52 9-89 19/07/26
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS JUL 26 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Outsource - 4 - Anodize	1 pcs	8/9/19	0.00 0.00	ATG 001	KH 2019-07-29
135 Packaging 2-1 - Receive - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	

				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
140 QC 6	1 pcs	8/9/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	40
				QC 6 - 40	JUL 30 2019 9-89
				QC 6 - 81	
145 Small Fab - 3 - B4B	1 pcs	8/9/19	0.00 0.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	• A2 19-7-30
				Small Fab - 7 - B4B	
150 QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	AUG 01 2019 DAS
				QC 5 - 61	40
				QC 5 - 81	9-89
170 QC 4	1 pcs	8/9/19	0.00 0.00	QC 4 - 28	DAS
				QC 4 - 58	75
				QC 4 - 69	9-89
				QC 4 - 9	
				QC 4 - 46	AUG 02 2019
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	DAS
180 Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B	75
				Packaging 3 - 2 - B4B	9-89
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	AUG 02 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	



See
Marcel
for Concession

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AUG 2, 2019

			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
190 DC - 1 - B4B	1	8/9/19	0.00 0.00	DC - 1 - B4B
	pcs			DC - 2 - B4B
200 QC 21 - FG	1	8/9/19	0.00 0.00	QC 21 - FG - 21
	pcs			QC 21 - FG - 70
				QC 21 - FG - 53

Part Op 110 - PULL FROM STOCK

Descriptions: 115 - REMOVE D4842-041 OUT FROM KIT, DISASSEMBLE AND KEEP HARDWARE TO REASSEMBLE.
120 - FACE DOWN (0.005") EACH D4842 AS PER DWG AND DEBURR.
125 - QC5- Inspect part completeness to step on W/O
130 - Issue P/O : 44131 AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED
145 - REASSEMBLE USING ORIGINAL HARDWARE AS PER DWG Assemble as per dwg and apply loctite 598 on all faying surfaces.
170 - (QC4- 100% Inspect kits for completeness)
180 - Identify and pack for shipping as per PPP 6F9540V00231
190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6F9540V00231 M321042L08 M327039-08-19	AW169 Lower Cutter Installation Assembly	1 pcs (1 ea) 12 12	110-Packaging 1 - Pick Kit	5195504 5195124 5006968

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	6F9540V00231	1	4	0

Part Specifications

Specifications could not be found.

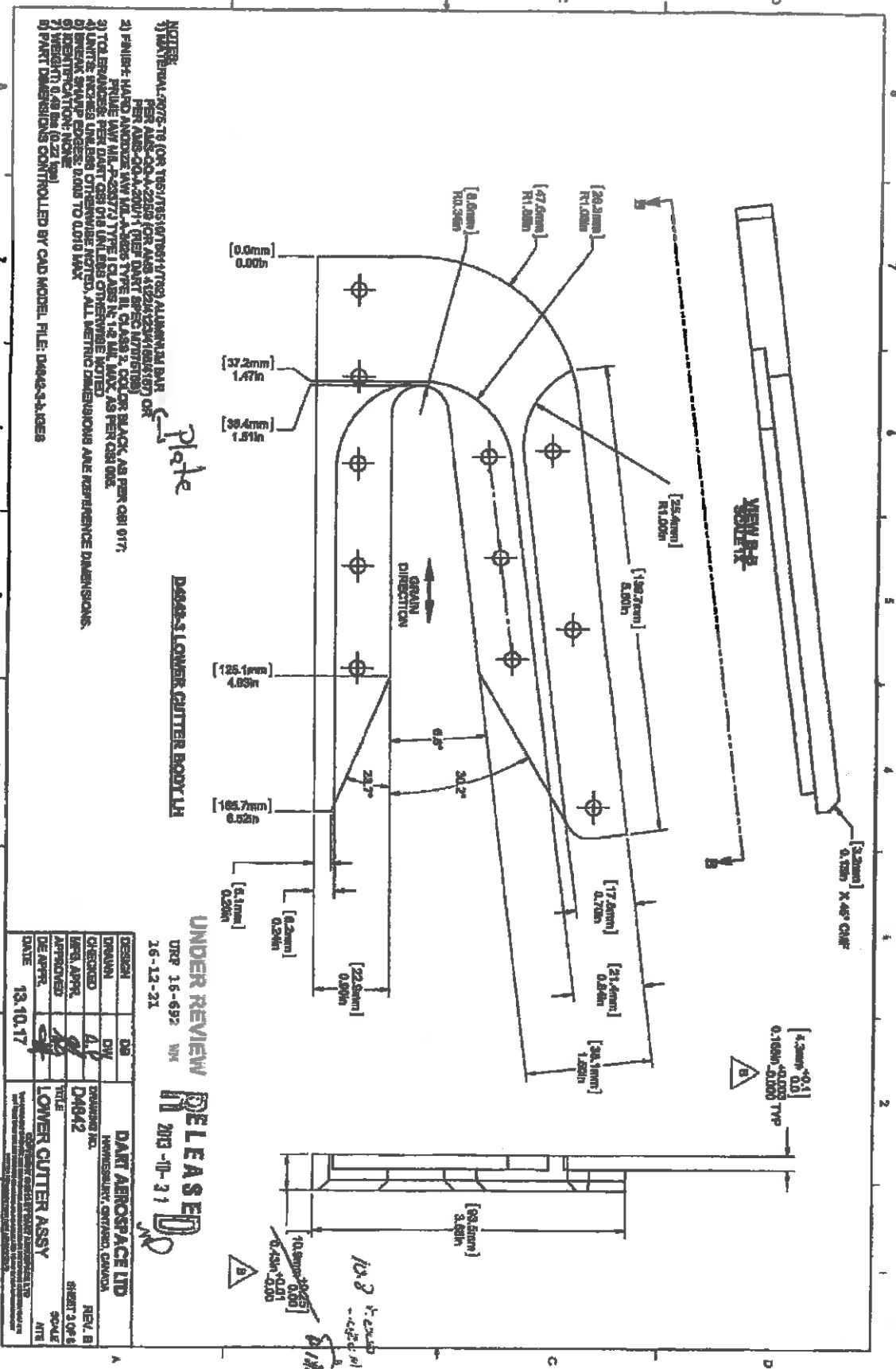


Dart Hawkesbury
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Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date	Invent Type
Part Number: 6F9540V00231 Revision: AW169 Lower Cutter Installation Assembly																	
200	QC 21 - FG	S171709	192034		1 pcs	0	S171709	GA026		Stock	4/11/2019	*					False
		S195550	192031		1 pcs	0	S195550	Concession	Bin	Stock	7/3/2019	*			CHG002		False
		S195594	192032		1 pcs	0	S195594	Concession	Bin	Concession	7/3/2019	*			CHG002		False
		S195595	192030		1 pcs	0	S195595	Concession	Bin	Concession	7/3/2019	*			CHG002		False
Operation Totals:		4			4	0											
Part Totals:		4			4	0											
Totals:		4			4	0											

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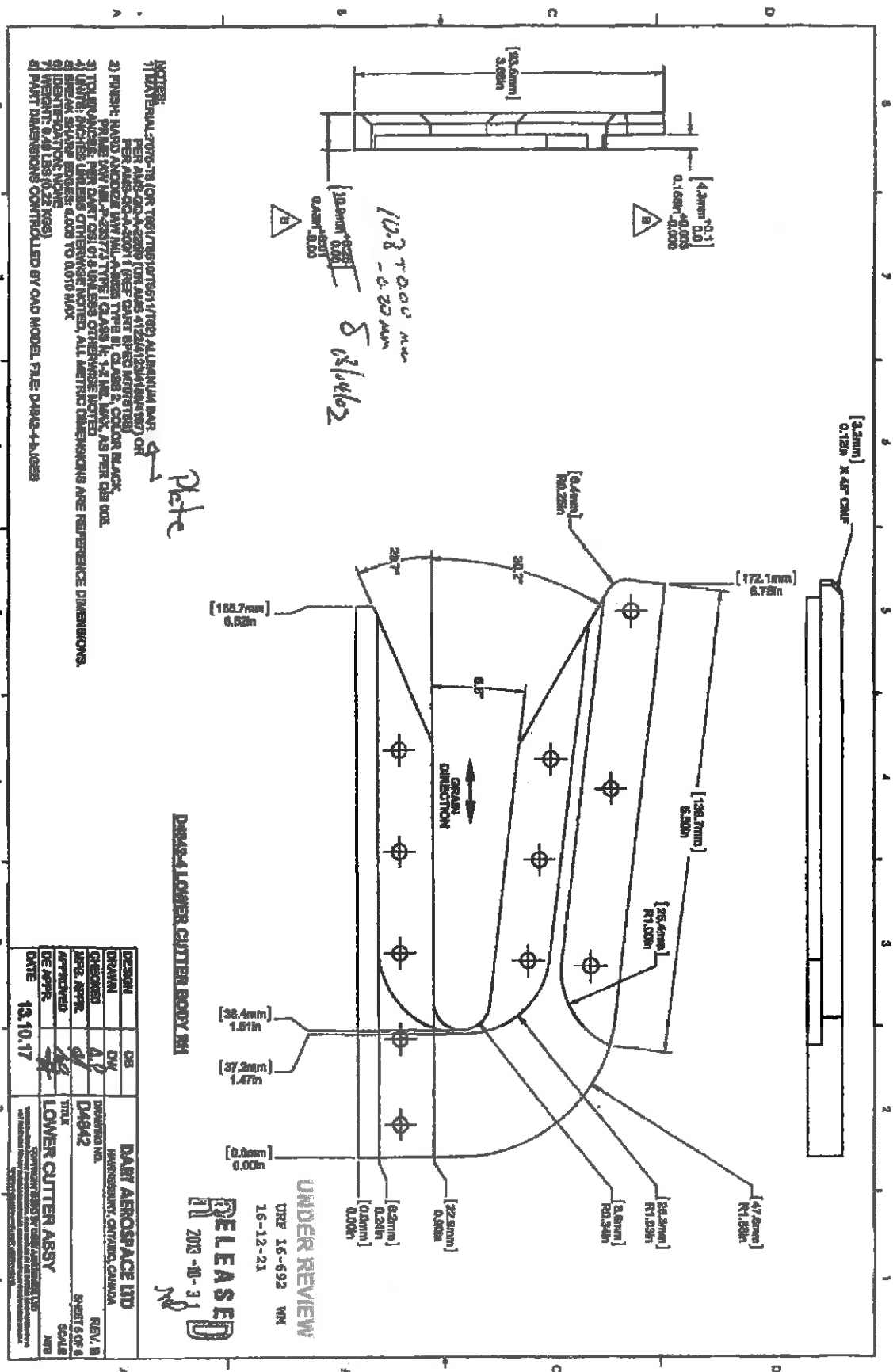


NOTES:
 1) MATERIAL: 7075-T6 (OR 7050/7050-T6) ALUMINUM BAR
 2) FINISH: HAND ANODIZE W/ MIL-A-8625 TYPE II, CLASS 2, COOL OR BLACK, AS PER CR 917.
 3) TOLERANCES: PER CR 917 UNLESS OTHERWISE NOTED.
 4) DIMENSIONS: UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
 5) WEIGHT: 1.43kg (3.22lb)
 6) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4642-1-1002

UNDER REVIEW
 D4642-1 LOWER CUTTER BODY LH
 26-12-21
 DRAFT 1.5-692 V1

DESIGN	D4642	DATE	13.10.17
DRAWN	D4642	DATE	13.10.17
CHECKED	A. J.	DATE	13.10.17
APPROVED	A. J.	DATE	13.10.17
TITLE: LOWER CUTTER ASSY			
SCALE: 1:1			
DRAWING NO.: D4642			
DESIGNED BY: D4642			
DRAWN BY: D4642			
CHECKED BY: A. J.			
APPROVED BY: A. J.			
DATE: 13.10.17			

1



- NOTES:
- 1) MATERIAL: 2017-T6 (OR T601/T601/T601/T601) ALUMINUM BAR
 - 2) FINISH: HAZARD FREE POLISH (OR TYPE II, CLASS 2, COLOR BLACK)
 - 3) TOLERANCES: UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE PER AS BUILT
 - 4) HOLE LOCATIONS: UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE PER AS BUILT
 - 5) HOLE SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.40 LBS (0.22 KGS)
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4642-14.1025

DESIGN	DATE	BY	DAI AEROSPACE LTD
DRAWN	DW		INTERMEDIATE, ONTARIO, CANADA
CHECKED	DW		
APPROVED	13.10.17		D4642
DATE	13.10.17		LOWER CUTTER ASSY
			SCALE
			MTD

UNDER REVIEW
DME 3.6-692 WK
1.6-12-21

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only

Job: <u>R198313</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering											
Part No. <u>6fa540100231</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube Machining Large Fab ☐		Cross tube Small Fab Finishing ☐		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐		Water Jet Supplier Quality ☐									
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition		DAS (OSINAC) 51 19/07/25 9-89		Completed By		Lead hand/ Supervisor									
Description Work Order Deviation Remove 0.005 of Material from base face for the following Parts 04842-3 and 04842-4 (see attached Drawing) Measurement SA 0.425 0.000 + 0.008 also at assembly use bolt 3x and washer 3x at base of cable cutter. tighten snug for the time being when Sealant dries up. the remove bolts and washers				re-work 04842-041 as per attached instructions/drawing				QC / QA Coordinator		DAS 68									
								JUL 28 2019											
Root Cause				FAULT CATEGORY															
Operator ☐				Pressure/Forced ☐				Contamination ☐				Power Loss/Surge ☐				Positioned Wrong ☐			
Manufacturing Process ☐				Bending ☐				Misaligned/off center ☐				Folio/Program ☐				Outside Tolerance ☐			
Equip/Tooling ☐				Crushing ☐				BOM/Route ☐				Grain Direction ☐				Drawing ☐			
Handling/Preservation ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Finish ☐			
Material ☐				Crimp/Kink/Ripple/Wave/Twist ☐				Incomplete/Unclear Instructions ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Product Improvement ☐				Marks/Chatter ☐				Drill Holes ☐				Out of Sequence ☐				Misread ☐			
Process Improvement ☐				Mislabeled ☐				Fit/Function ☐				Off-set/Set-up ☐							
Human Factors ☐				Other/Details: _____															



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044131



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044131

PO Date: 7/29/19

Due Date: 7/31/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ****RUSH****

E-MAILED
2019-07-30

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R198348	D4842-3	Lower Cutter Body, LH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	8 pcs	0 pcs	8 pcs	\$22.50/pcs	\$180.00
				X8		JUL 30 2019					DP
											\$100813
2	R198349	D4842-4	Lower Cutter Body, RH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00
				X4		JUL 30 2019					DP
											\$188321



Tel (613) 632-5200

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Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER
POHB044131



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 10:28 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: D4842-3 Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25663 PO: POHB044131		Rev: B Line: 1
4 ea	Part: D4842-4 Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25664 PO: POHB044131		Rev: B Line: 2
3 ea	Part: 6F9540V00231 AW169 Lower Cutter Instal Ass Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25665 PO: POHB044131		Rev: Line: 3
1 ea	Part: D4842-041 Lower Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: B
Made in Canada.			

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Made in Canada.



A.T.G. Industries Inc.
780 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0001-.0002" (1 - 2 mils) per drawing. Job: 25666 PO: POHB044131		
	Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 30 2019</u> Certified Signature: <u>/</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED

JUL 30 2019

DART AEROSPACE LTD.